

Work Order ID 163320

Tuesday, June 27, 2017 12:06:46 PM

163320

Page 1

Item ID: D3794-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Aft

Start Date: 7/5/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 03 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3794	Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.51

FLOW CNC Waterjet

1-Cut as per Dwg D3794 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary(13)06/27/07/03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.10

Quality Control

(13)06/27/07/03

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.20

Quality Control

13DAS
38
9-89

JUL 04 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

Memo

LOCATION : FP001

0.10

13

DAS
6
9-89

JUL 06 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

1.00

17/7/6 J

DAS
21
9-89

JUL 06 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, June 27, 2017 12:06:44 PM

Page 1

Work Order ID: 163320

163320

Parent Item: D3794-3

D3794-3

Parent Item Name: Gasket Aft

Start Date: 7/5/2017

Required Date: 7/14/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	118.4269	1.2828	14.25333			

MNEO60S 063

NEOPRENE SHEET 0.063

No.110750002 NEOPRENE DURO 60+/-5 "A" 1/16" IMPORT GR PT

**

06/17/07/03

Location

Loc Qty

Loc Code

GA

8.2149

M131990

8.2149

MAT

31.8

M135551

31.8

MAT052

78.412

M136565

9.762

M137313

68.65

14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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DART AEROSPACE LTD		Work Order: 163320
Description: Gasket		Part Number: D3794-3
Inspection Dwg: D3794 Rev: A		Page 1 of 1

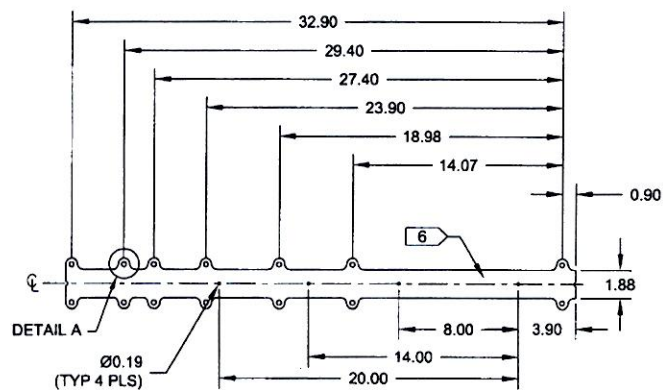
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

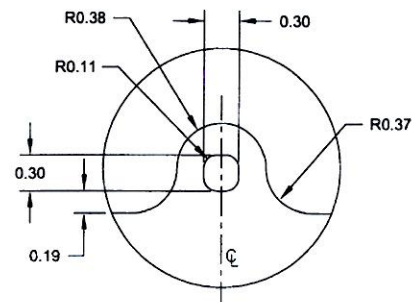
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	Ø.19	1		View 2	
0.300 x 0.300	+/-0.010	0.300x.300	1		T-p	
1.88	+/-0.030	1.88	1			
4.281	+/-0.010	4.281	1			
6.44	+/-0.030	6.44	1			
6.00	+/-0.030	6.00	1			
6.75	+/-0.030	6.75	1			
2.00	+/-0.030	2.00	1			
4.75	+/-0.030	4.75	1			
9.50	+/-0.030	9.50	1			
14.25	+/-0.030	14.25	1			
17.75	+/-0.030	17.75	1			
26.74	+/-0.030	26.74	1			
29.23	+/-0.030	29.23	1			

Measured by: [Signature]	Audited by: DAS 38	Prototype Approval:	N/A
Date: 17/07/03	Date: 11/11/03	Date:	N/A

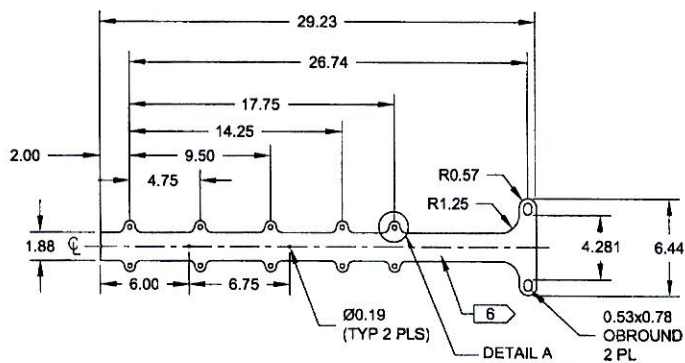
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD [Signature]	[Signature]



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER
(REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163320 MWS
170703

RELEASED
08-05-14

A		NEW ISSUE		PH	08.05.14
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3794			SHEET 1 OF 1
APPROVED		TITLE			SCALE
DE APPR.		GASKET			NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			